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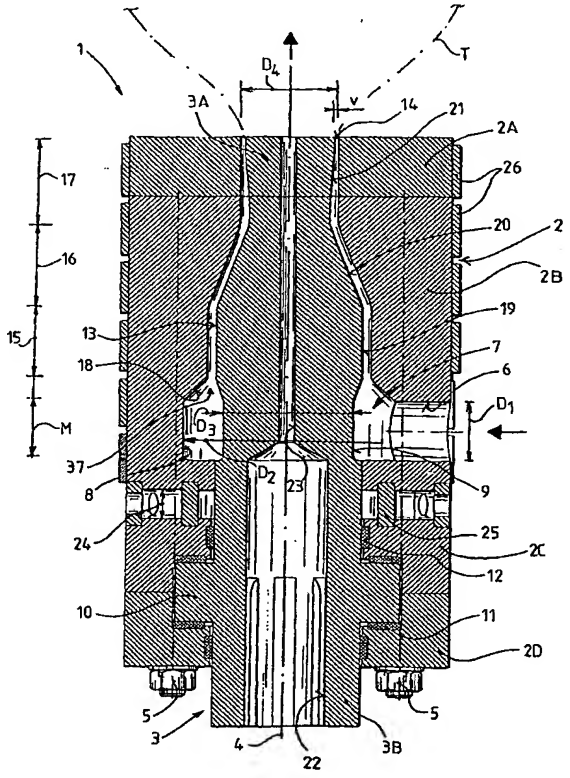
(54) Title: PROCESS AND EXTRUDER NOZZLE FOR PRODUCING TUBULAR EXTRUDED PRODUCTS



(57) Abstract: This invention relates to a process and an extruder nozzle (1) for extruding tubular products, particularly blown plastic foil hoses (T). This process comprises the steps of feeding a pressurized material into an extruder nozzle (1) through an inlet (6), and forcing this material flow through a duct formed between an outer and an inner nozzle components (2, 3), then shaping the tubular product by pressing the material flow through an annular aperture (14) at the duct end. The essence lies in that the material flow entering the extruder nozzle (1) is distributed first by feeding into an annular expansion chamber (7), the cross-section of which is selected much greater, that of the inlet (6). When the expansion chamber (7) has been completely filled up by the material whose pressure has become higher than the flow resistance of an homogenizing ring channel (13) having a cross-section narrowed to and connected to the annular expansion chamber (7) then in the homogenizing ring channel (13) the material flow is forced to move in cross direction to the entering direction thereof, and it is homogenized by the relative rotation of surfaces partly delimiting at least the homogenizing ring channel (13). The material flow is led to a drawing aperture (14) by way of a helical forced movement.

WO 2004/112485 A1

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